

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011514**Date Inspected:** 16-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Ying Xin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 10

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% and randomly Visual Testing of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as Tower Splice Plate. The weld designations reviewed are as follows.

ND1-A5002-19-1A/B ~ 32-1A/B,

SD1-A5002-37-1A/B ~ 40-1A/B.

NDT Notification No: 005066

This QA Inspector observed the following work in progress:

BAY 10**Repair Welding**

This QA Inspector observed ZPMC qualified welding personnel identified as 053869 perform Flux Core Arc

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Welding (FCAW) on North Tower lift 4, D/E corner joint. Joint identified as NSTL4-3B/L-2B, ZPMC QC Identified as Lia Zhong An. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-1G (1F)-FCM-Repair.

Tower Trial Assembly:

This QA Inspector observed ZPMC qualified welding personnel identified as 070046. perform Flux Core Arc Welding (FCAW) on East Tower. Joint identified as ESD1-SA233-22, Skin B, ZPMC QC Identified as Qiu Wen Tiny. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 070478. perform Flux Core Arc Welding (FCAW) on East Tower. Joint identified as ESD1-SA296-30, Skin D, ZPMC QC Identified as Qiu Wen Tiny. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 070254. perform Flux Core Arc Welding (FCAW) on West Tower. Joint identified as WSD1-SA279-21, Skin B, ZPMC CWI Identified as Zhao Chen Sun. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 068765. perform Flux Core Arc Welding (FCAW) on West Tower. Joint identified as WSD1-SA294-F/G-59, ZPMC CWI Identified as Zhao Chen Sun. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 068864. perform Flux Core Arc Welding (FCAW) on West Tower. Joint identified as WSD1-SA295-B/E-25, ZPMC CWI Identified as Zhao Chen Sun. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this projec

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest phone: 15000422360, who represents the Office of Structural Materials for your project.

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Inspected By: Gaikwad,Shailesh

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer